

Work Order ID 61829

Tuesday, September 07, 2010 3:14:49 PM



Page 1

Item ID: D3908-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Aft Crosstube

Start Date: 9/7/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3908

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3908

304 . 125

Prog Rev: 5

Dwg Rev: 2

Deburr as required

B10-9-16

Pro →

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-9-16

W/O: 61829		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/9/16	# 120	Took qty x1 for qc inspection template	S	10/9/16	x1		S 10/9/16

Part No: D3908-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10/09/10

XS

150

Identify as per dwg & Stock Location. QB

0.00



Packaging

Memo

0.00

Packaging

10/9/10 SP (9x)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/10

MF 10-9-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 07, 2010 3:14:55 PM

Page 1

Work Order ID: 61829

Parent Item: D3908-1

Parent Item Name: Lug Plate, Aft Crosstube



Start Date: 9/7/2010

Required Date: 9/13/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per PC1
10.05.27 DD verf:EC IPP Rev:D per ECN10-581 10.05.28
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	68.7423	0.0533 	0.448842	7.1		
304/316 0.125 Sheet													

1810-9-16

Location

Loc Qty

Loc Code

MAT

68.7423

114799

68.7423

114799

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	61829
Description: Lug Plate, Aft Crosstube		Part Number:	D3908-1
Inspection Dwg: D3908	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.129	✓		V 1B02	
Ø0.191	+0.005/-0.001	.192	✓		V	
Ø0.257	+0.006/-0.001	.257	✓		V	
Ø0.375	+0.006/-0.001	.374	✓		V	
0.310	+/-0.010	.310	✓		V	
0.380	+/-0.010	.379	✓		V	
0.750	+/-0.010	.756	✓		V	
0.469	+/-0.010	.466	✓		V	
3.25	+/-0.030	3.253	✓		V	
0.65	+/-0.030	.649	✓		V	
0.63	+/-0.030	.628	✓		V	
1.587	+/-0.010	1.586	✓		V	
1.588	+/-0.010	1.588	✓		V	
5.46	+/-0.030	5.460	✓		V	
3.80	+/-0.030	3.797	✓		V	
2.13	+/-0.030	2.131	✓		V	
1.313	+/-0.010	1.311	✓		V	
0.375	+/-0.010	.377	✓		V	
0.625	+/-0.010	.625	✓		V	
11.15	+/-0.030	11.15	✓		V 1B01	
0.375	+/-0.010	.377	✓		V	
0.750	+/-0.010	.753	✓		V	
0.125	+/-0.010	.119	✓		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 10-9-16	Date: 10/09/16	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dimensions updated per Dwg Rev B	KJ	
C	10.06.07	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
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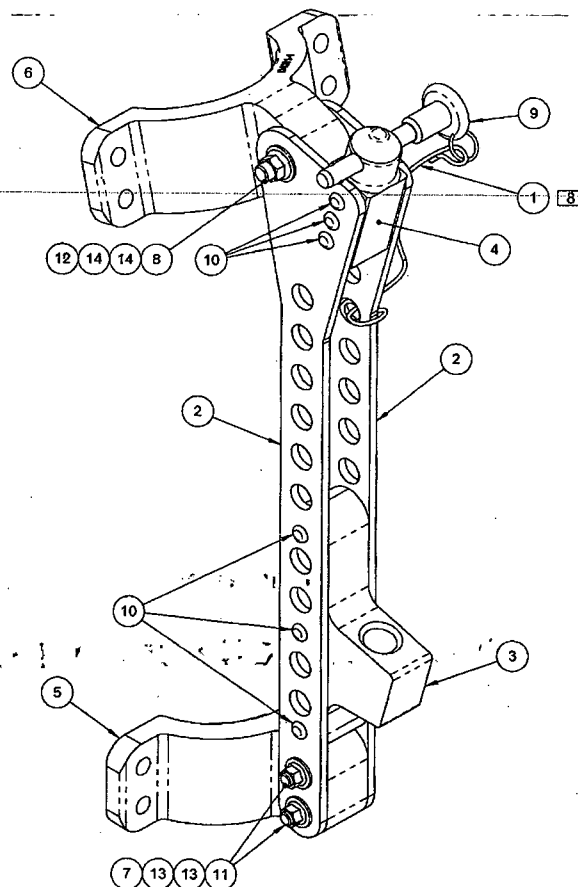
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NO ONE
V. 01829
NO. 10-907

RELEASED
2010-05-28
W

D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

REV.	DESCRIPTION	BY	DATE
C	REDESIGNED ITEM #2; ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413, SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
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DATE	10.05.27		

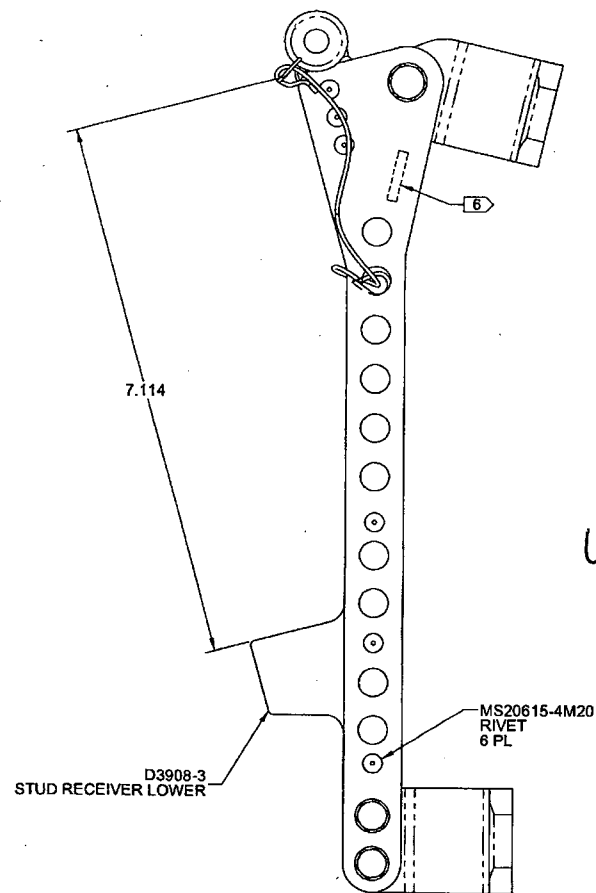
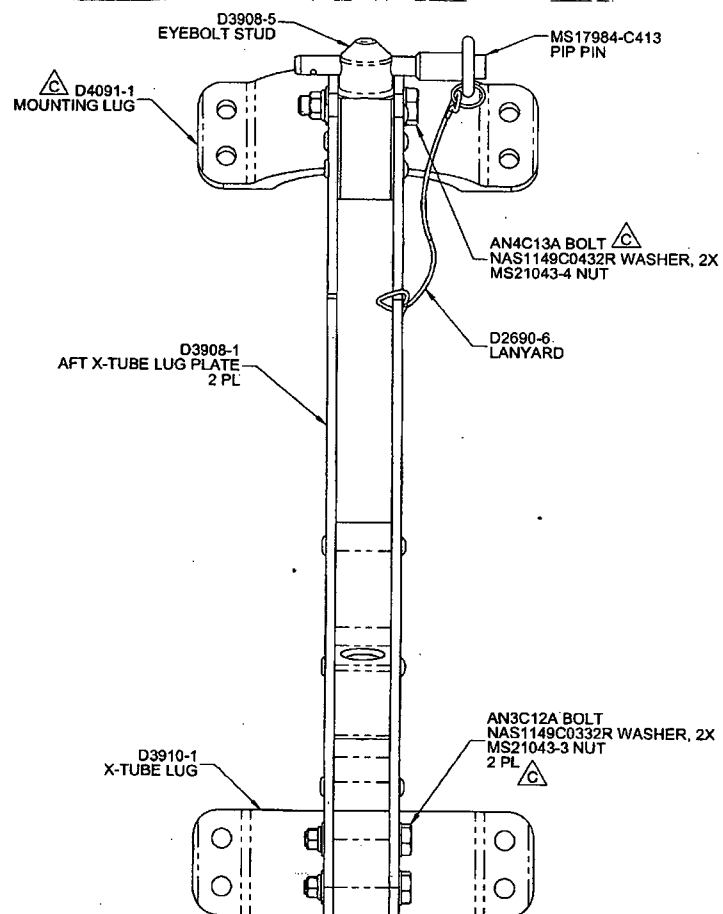
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NOTE: Date & initial all entries



W/O 6189

RELEASED
2010-05-28
MP

D3908-041 X-TUBE LUG ASSY (AFT)

DESIGN	JRH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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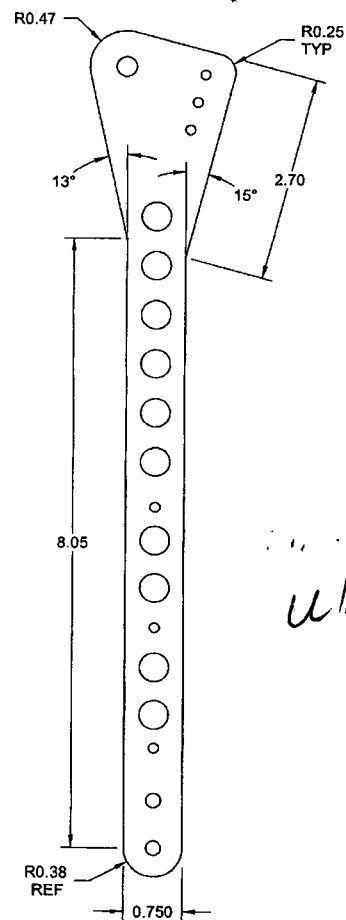
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RELEASED
2010-05-28

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE 

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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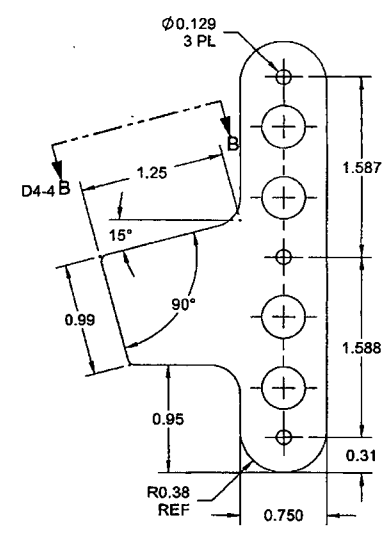
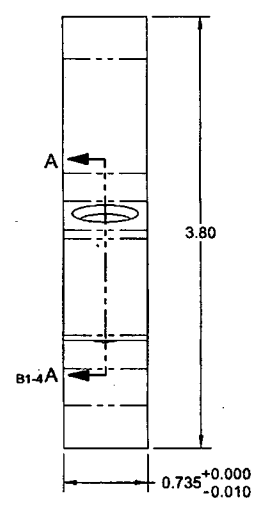
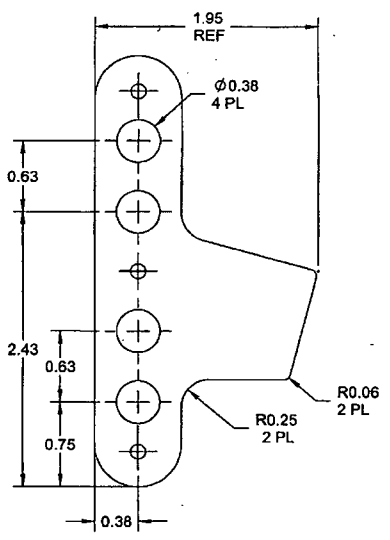
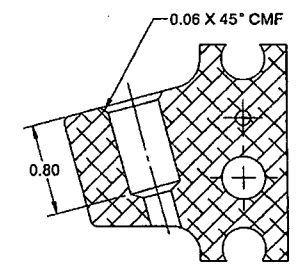
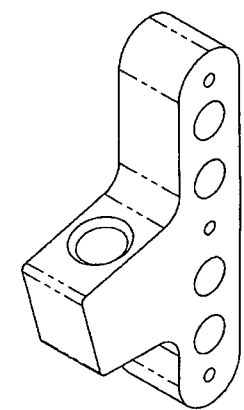
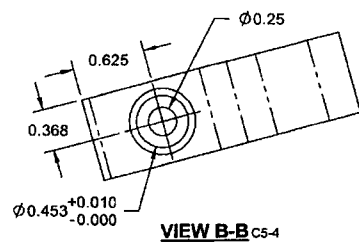
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NOTE: Date & initial all entries



D3908-3 STUD RECEIVER LOWER

SECTION A-A 86-4

RELEASED
2010-05-28

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 PER DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.69 lbs

w/o 61829

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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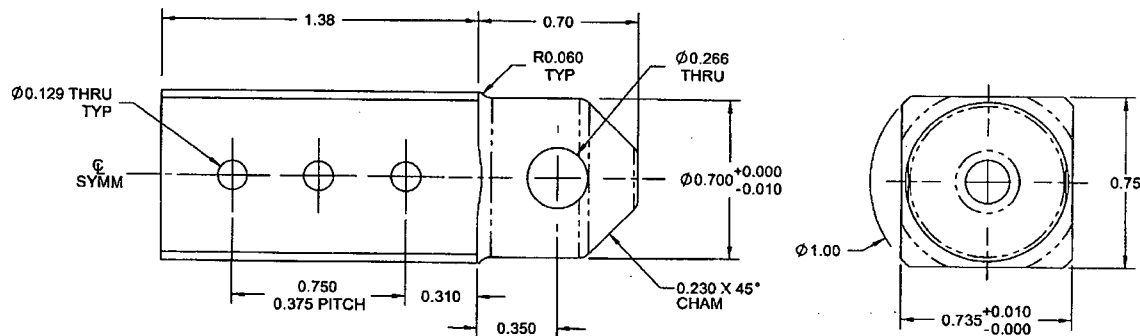
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3908-5 EYEBOLT STUD

W/O 41825

RELEASED
2010-05-28
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 5 OF 5
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